

Abstract of the Disclosure

5 A planetary gear system is provided where the sun and planet gears are of welded, one-piece double helical construction. Further provided is a method of forming a planetary gear system, and the sun and planet gears for such a system, by welding together two parts of the sun and planet gears, each part having helical gear teeth, to provide sun and planet gears of welded, one-piece double helical construction.